

Work Order ID 55462

January 19, 2010 9:49:38 AM

Page 1

Item ID: D2600-3-BENT

Accept

Setup Start

Revision ID:

Stop

Item Name: Extrusion Bent

Start Date: 1/19/10 Start Qty: 10.00

Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan:

Date: 10-1-19 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2600

Rev D1

100

0.00



CNC Bend 1

CNC Delta 100 Bender

BENDING MACHINE - SKIDTUBES

Memo

0.00

Pick qty 1 D2600-3-120 extrusion

1-Deburr one end of extrusion

2-Drill #30 pilot holes using DT8689

3-Open holes to 5/16" and deburr

4-Bend using CNC bending machine as per program 2750.C and Folio FT003.

5-Use 5/16 locator pin on buggy "A".

6-Check fit to Jig DT8150

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Quality Control

Memo

0.00

Inspect work to Step 6 Ensure fit to Jig DT8150

DC

Q

MS 10-01-26

DP

10-1-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Page 2

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Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

Identify as per dwg & Stock Location: **46**

0.00



Packaging

Memo

0.00

Packaging

DP

10-1-26

10

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/26

MF 10-1-26

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Picklist Print

January 19, 2010 9:49:43 AM

Page 1

Work Order ID: 55462



Parent Item: D2600-3-BENT



Parent Item Name: Extrusion Bent

Start Date: 1/19/10

Required Date: 1/25/10

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2600-3-120		Manufactured	No			100	Each	75.0000	10.0000			



Extrusion Round 3" 350



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

75

43960

42

46063

33

10 pcs

MB 10-01-26

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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. D SHEET 1 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1
A	97.01.21	NEW ISSUE	
B	97.09.09	CHANGE MATERIAL SPEC.	
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	
D	98.08.20	INCREASE MIN. UTS TO 40 KSI	
DI	01.04.17	ADD PART NUMBERS & DIE NUMBERS <i>4-CP</i>	

RELEASED
98.08.25 DS

GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED
TO ASTM STANDARD B221 BY AN APPROVED TESTING
FACILITY TO ENSURE THAT THE BATCH MEETS THE
ABOVE MINIMUM MECHANICAL PROPERTIES.

2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE
NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. *53462*
By 10-1-10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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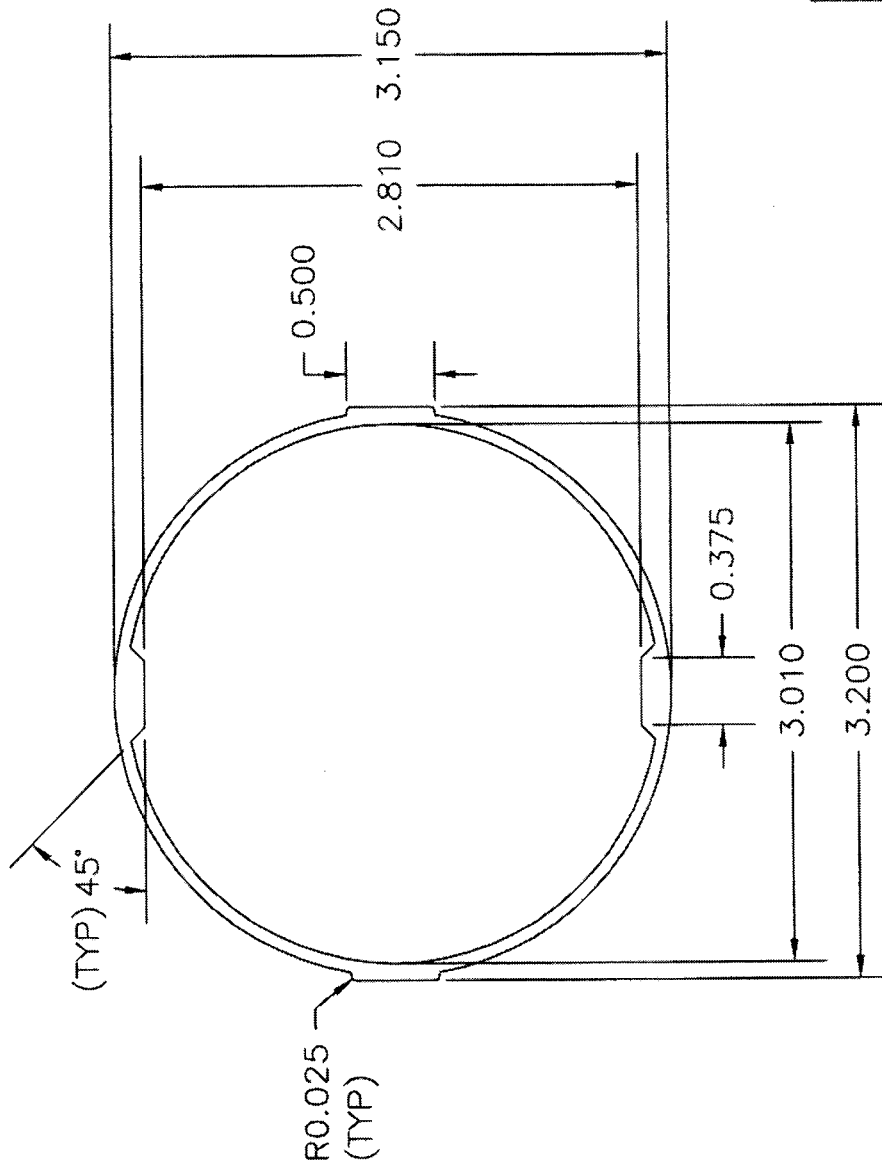
NOTE: Date & initial all entries



DESIGN <i>DD</i>	DRAWN BY <i>DD</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2600	REV. D SHEET 2 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

W/O 53462

RELEASED
98.8.25 DS



D2600-1

MANUFACTURED WITH CARADON INDALEX DIE # MH-18870
OR BON L DIE # 897121 (PREFERRED CHOICE)
PART NUMBER IS D2600-1-XX WHERE XX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 160" LONG)

51

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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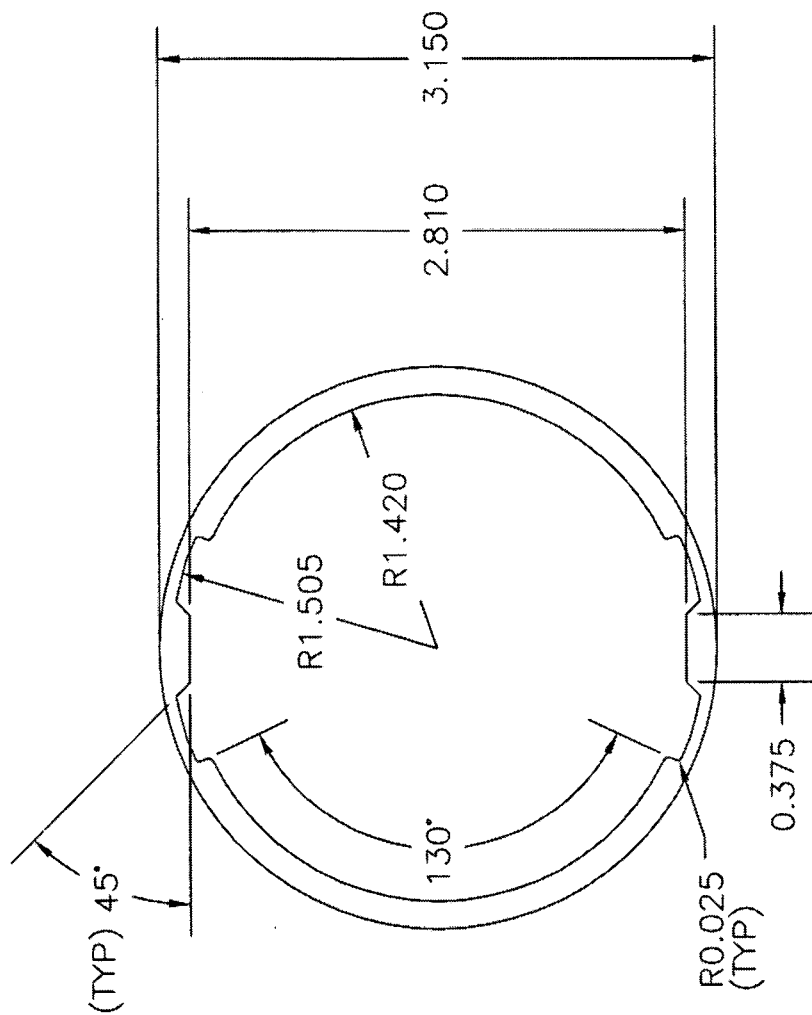
NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. D SHEET 3 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

410 55462

RELEASED
98.8.25 DS



D2600-3

MANUFACTURED WITH CARADON INDALEX DIE # MH-18859

OR BON L DIE # 897122 (PREFERRED CHOICE)

PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-3-120 IS 120" LONG)



W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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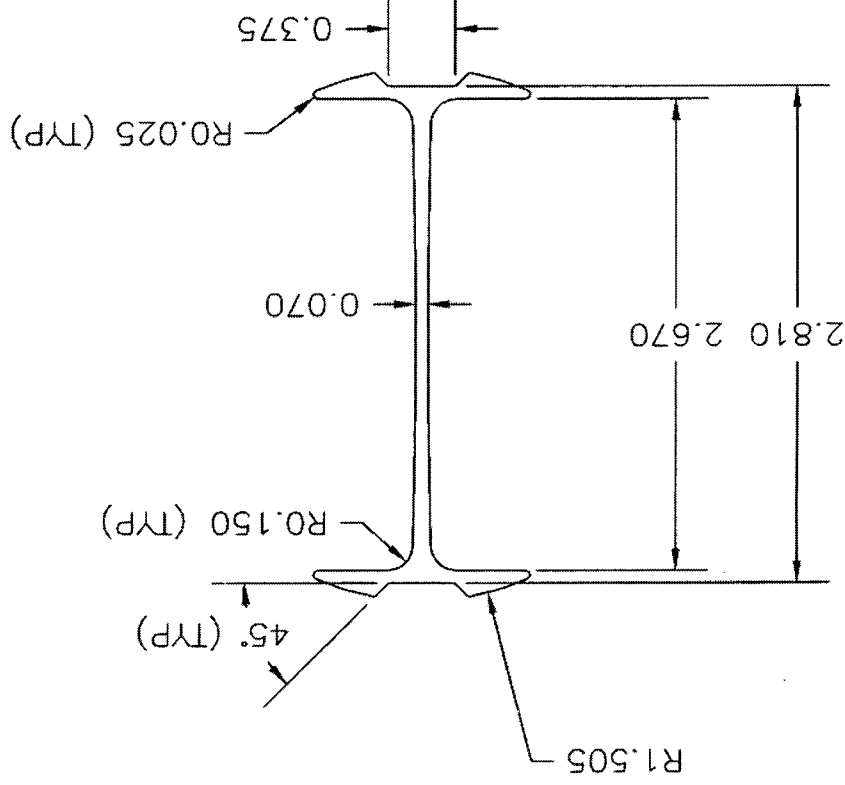
NOTE: Date & initial all entries

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE	DRAWING NO.	REV. D	SHEET 4 OF 5
98.08.20	D2600		
TITLE		SCALE	
EXTRUSION		1:1	

RELEASED
98 8 26 DS



D2600-5
MANUFACTURED WITH CARADON INDALOX DIE # MS-18871
PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-5-108 IS 108" LONG)



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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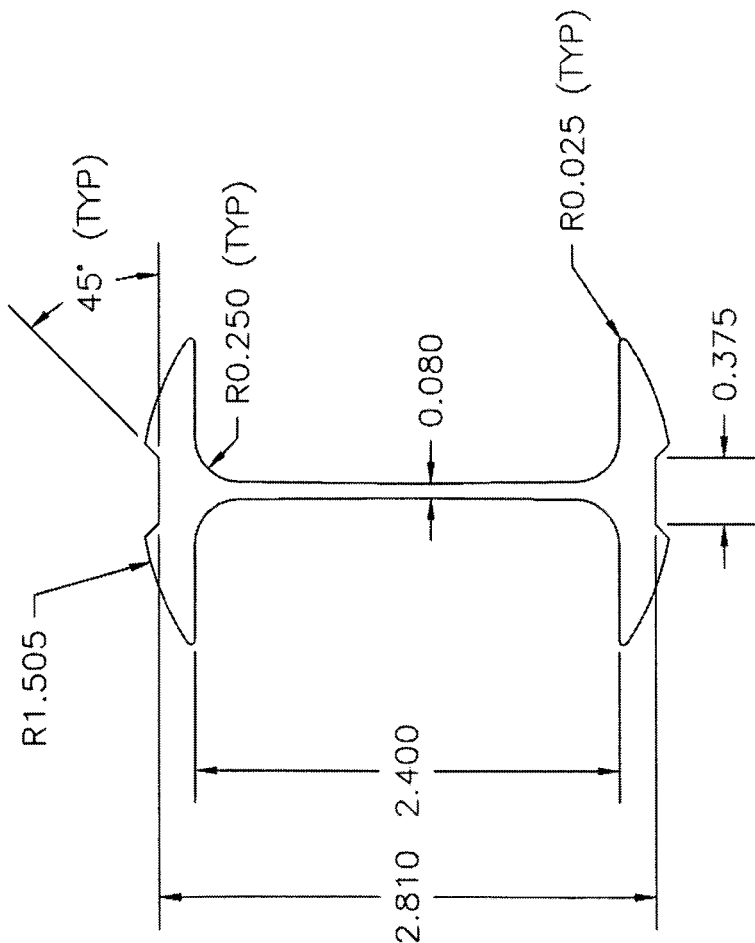
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DESIGN <i>DA</i>	DRAWN BY <i>DA</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>AS</i>	DRAWING NO. D2600	REV. D SHEET 5 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

W1055462

RELEASED
98.8.25 DS



D2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-7-125 IS 125" LONG)



W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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